

Work Order ID 56233



Page 1

Wednesday, February 17, 2010 10:06:33 AM

Item ID: D412-769-041

Accept



Setup

Start



Revision ID:

Item Name: Aft Facing Seat, LH

Stop



Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MP*

Date: 10-2-17 Tooling: _____ Date: _____

Run

Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	_____	_____	_____	_____	_____	_____	_____	_____
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IIN D412-769

Rev B/1

0.00

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D412-769-041

CHG 001

110



QC4- 100% Inspect kits for completeness

0.00

QC

Quality Control

Memo

0.00

120



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-769-041

Location: _____ PPP Rev: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-03-22	W/B Survey Handover	INN now 2 Rev.C., update drawing box. param change 10-03-22	AP	10.03.22		10-03-22	10-03-22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56233

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Wednesday, February 17, 2010 10:06:33 AM

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Accept



Setup Start



Revision ID:

Item Name: Aft Facing Seat, LH

Stop



Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

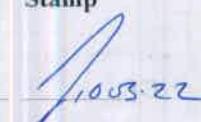


QC

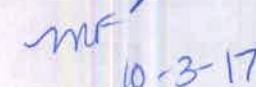
Quality Control

Memo

0.00



J.003.22



MF
10-3-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, February 17, 2010 10:06:32 AM

Work Order ID: 56233



Parent Item: D412-769-041



Parent Item Name: Aft Facing Seat, LH

Start Date: 2/18/2010

Required Date: 3/3/2010

Comments: IPP rev A 08-07-17 new issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D412-724-041		Manufactured		No		110	Each	0.0000	1.0000		B56241 10-3-89	
Head Rest Assembly, Center												
D412-724-043		Manufactured		No		110	Each	2.0000	1.0000		56875 10-3-11 sf	
Head Rest Assembly, LH												
			<u>Warehouse</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
			<u>Location</u>									
			Main Warehouse									
					FG		2					
					44408		2					
							110					
					Each		0.0000					
D412-769-043		Manufactured		No								
Aft Facing Seat Assembly, LH												

D412-769-043
Rev.B B56237

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
	1		D412-769-044	AFT FACING SEAT ASSEMBLY, RH
1	1		D412-724-041	HEAD REST ASSEMBLY, CENTER
1		1	D412-724-043	HEAD REST ASSEMBLY, LH
	1		D412-724-044	HEAD REST ASSEMBLY, RH

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Required Date: 3/3/2010 Req'd Qty: 1.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *MP*

Date: 10-2-17 Tooling:

Date:



QC:

Date: SPC (Y/N):

Date:



Sequence ID/ Work Center ID	Operation Description
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Draw Nbr	Revision Nbr
HIN D412-769	Rev B

100



DC
Document Control

DOCUMENT CONTROL

0.00

10-3-08

Memo 0.00

Photocopy bluefile & type labels per PPP D412-769-041 CHG 001

110



QC
Quality Control

QC4- 100% Inspect kits for completeness

0.00

REFERENCE ONLY

Memo 0.00

120



Packaging
Packaging

Packaging

0.00

Memo 0.00
Identify and pack for shipping as per PPP D412-769-041
Location: _____ PPP Rev: _____

